



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Rush!!!

D4436-043

Job Sheet 188753



Part No: D4436-043

Job Qty: 6 pcs

Part Name: Aft Outboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP REV:B 12.01.24 PER DWG REV.A DD
VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		1/31/19	0.00	0.91	Waterjet - Flow		SC 19/02/12
110	QC 2	6 pcs		1/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		SC 19/02/12
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartero.com
www.dartaerospace.com

Container No: S152797



Part: D4436-043

Job No: 188753

Serial No/Batch: S152797

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/12/19

120	QC 8	6 pcs	1/31/19	0.00 0.00	QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
130	Small Fab - Brake NC - B4B	6 pcs	1/31/19	0.06 0.52	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	Small Fab - 2 - B4B	6 pcs	1/31/19	0.00 0.70	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
150	QC 5	6 pcs	1/31/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
160	Handfinish - 1-1 Chemical-B4B	6 pcs	1/31/19	0.00 0.69	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
Plex 1/21/19 3:21 PM Dart.Hadley.Shannon						

				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/2/15
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	6 pcs	1/31/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	DAS
				QC 7 - 36	36
				QC 7 - 37	9-89
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
180 Small Fab - 3 - B4B	6 pcs	1/31/19	0.00 0.70	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	DAS
				Small Fab - 4 - B4B	36
				Small Fab - 5 - B4B	9-89
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
185 QC 5	6 pcs	1/31/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
190	Powdercoat - 4 Black Sand - B4B	6 pcs	1/31/19	0.00 0.29	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
200	QC 3	6 pcs	1/31/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
202	Small Fab - 4 - B4B	6 pcs	1/31/19	0.00 0.70	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
205	QC 5	6 pcs	1/31/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
210	Packaging 3-1 - Stock - B4B	6 pcs	1/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

BL19-2-A.

START: 11:00 OUT: 3:30 FINISH: 11:30

DAS
58 FEB 19 2019
9-89

DAS
58 FEB 19 2019
9-89

DAS
FEB 19 2019 68
9-89

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	54 FEB 22 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6	1/31/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	

Part Op **100** - 1-Cut D4436-1 as per Dwg Dwg Rev: **B** Prog Rev: **B** 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Bend/Assemble as per dwg)
140 - (Small Fab) C"SINK AS PER DWG
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Chemical Conversion Coat per QSI005 4.1)
170 - (QC7-Inspect Chemical Conversion Coat)
180 - (Small Fab) Assemble as per dwg, do not install rubber seal.
185 - (QC5- Inspect part completeness to step on W/O)
190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
200 - (QC3- Inspect Part Finish)
202 - (Small Fab) Install rubber seal as per dwg 3M 1300 batch: _____
205 - (QC5- Inspect part completeness to step on W/O)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	9.5400 sf (1.59 ea)	100-Waterjet - Flow - 1	5152150
MS20426AD3-7	Rivet	24 Ea (4 ea)	180-Small Fab - 3 - B4B	5018535
MS21075L08	Anchor Nut	12 Ea (2 ea)	180-Small Fab - 3 - B4B	5123462
D4441-1	Rubber Seal	8.4480 ft (1.408 ea)	202-Small Fab - 4 - B4B	50147552
				5092107

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	10	11	0
180-Small Fab - 3 - B4B	MS20426AD3-2	24	18,520	0
	MS21075L08	12	52	0
202-Small Fab - 4 - B4B	D4441-1	8	473	0
Part Specifications				
Specifications could not be found.				

Plex 1/21/19 3:21 PM Dart.Hadley.Shannon



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D4436-043
Job Sheet 188753



Part No: D4436-043

Job Qty: 6 ea

Part Name: Aft Outboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP REV:B 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		1/31/19	0.00	0.91	Waterjet - Flow		
110	QC	6 pcs		1/31/19	0.00	0.00	QC2 Waterjet-3		
120	QC	6 pcs		1/31/19	0.00	0.00	QC8-4		
130	Brake NC	6 pcs		1/31/19	0.06	0.52	Brake NC 2		
140	Small Fab	6 pcs		1/31/19	0.00	0.70	Small Fab-6		
150	QC	6 pcs		1/31/19	0.00	0.00	QC5		
160	HandFinish	6 pcs		1/31/19	0.00	0.69	HandFinish1		
170	QC	6 pcs		1/31/19	0.00	0.00	QC7-3		
180	Small Fab	6 pcs		1/31/19	0.00	0.70	Small Fab-6		
185	QC	6 pcs		1/31/19	0.00	0.00	QC5		
190	Powdercoat	6 pcs		1/31/19	0.00	0.29	Powdercoat4		
200	QC	6 pcs		1/31/19	0.00	0.00	QC3		
202	Small Fab	6 pcs		1/31/19	0.00	0.70	Small Fab-6		
205	QC	6 pcs		1/31/19	0.00	0.00	QC5		
210	Packaging	6 pcs		1/31/19	0.00	0.00	Packaging3-2		
220	QC21-SA	6 Ea		1/31/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut D4436-1 as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary

Descriptions: 140 - C"SINK AS PER DWG

180 - Assemble as per dwg, do not install rubber seal.

190 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

202 - Install rubber seal as per dwg 3M 1300 batch: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	9.5400 sf (1.59 ea)	100-Waterjet - Flow - 1	
MS20426AD3-2	Rivet	24 Ea (4 ea)	180-Small Fab	
MS21075L08	Anchor Nut	12 Ea (2 ea)	180-Small Fab	
D4441-1	Rubber Seal	8.4480 ft (1.408 ea)	202-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

100-Waterjet - Flow - 1	M6061T6S.040	10	11	0
180-Small Fab	MS20426AD3-2	24	18,520	0
202-Small Fab	MS21075L08	12	81	0
	D4441-1	8	476	0
Part Specifications				
Specifications could not be found.				

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

